

Date: Monday, 9/10/2007 1:31:15 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	206 L WEB
Job Number	34509	Part Number	D26547
Estimate Number	10722	Drawing Number	D2654 REV E1
P.O. Number	N/A	Project Number	N/A
This Issue	9/10/2007	S.O. No.	N/A
Prsht Rev.	NC	Type	LANDING GEAR
First Issue	N/A	Material	N/A
Previous Run	34169	Due Date	9/17/2007
Written By			
Checked & Approved By	07.09.11		
Comment	Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:e 06.04.05 Added level21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26007140	EXT. "I BEAM" THICK
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	AWM 07/09/11
	Pick: Qty Part Number Description Batch	B-21966 A
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1	AWM 07/09/12 6
	1-Cut D2600-7 to length as per Dwg D2654	
	2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654	
	3-Using the uni-bit, open holes to finish size as per Dwg D2654	
	4-Deburr holes and ends	
3.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	En 07/09/12 6
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1	32-7-9-12
	Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34509		Part Number: D26547
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  DP 2-9-13
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
6.0	PACKAGING 1	PACKAGING RESOURCE #1  5/6/09-13
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LC		
7.0	QC21	FINAL INSPECTION/W/O RELEASE  6 09/13
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 9/9/13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

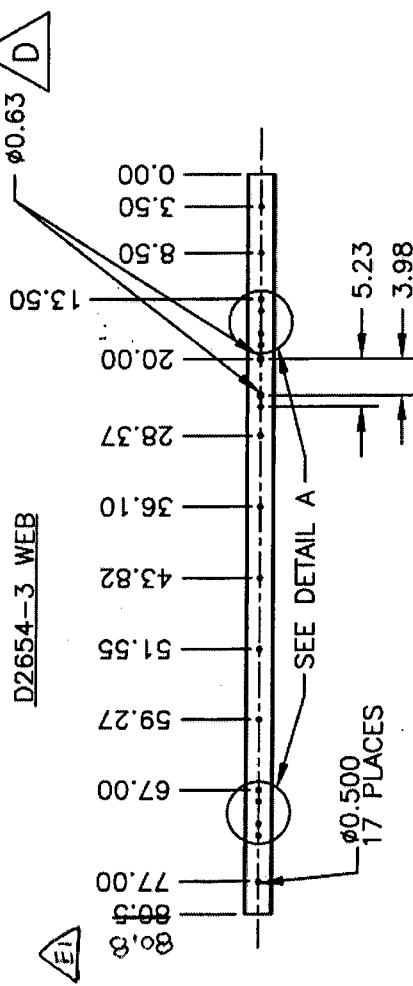
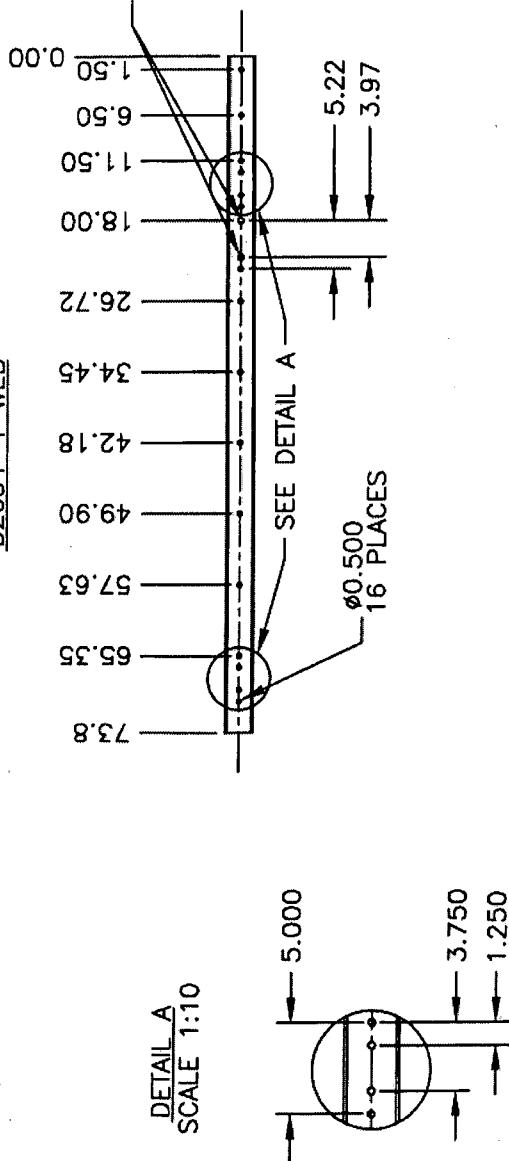
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CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE
04.05.26		WEB

RELEASED
04.06.22

A	97.03.25	NEW ISSUE
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438
C	97.10.29	CHANGED HOLE PATTERN
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$
E	04.05.26	CHANGE LENGTHS, REFORMAT
E1	04.08.24	PER TOOLING; 80.8 WAS 80.5

D2654-1 WEB

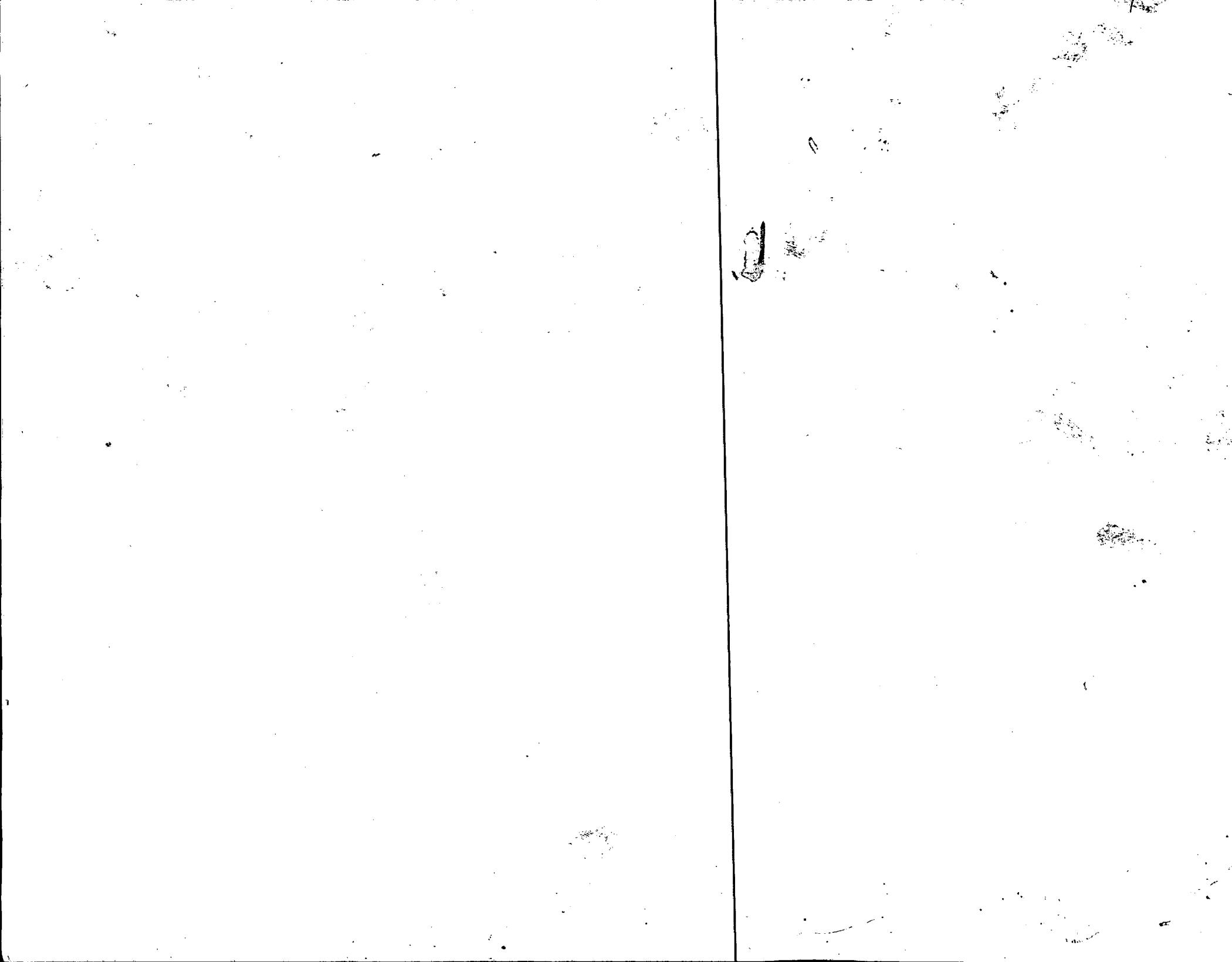


MAKE FROM D2600-5-108 EXTRUSION
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CHECKED	APPROVED	DRAWING NO. D2654
DATE		TITLE WEB

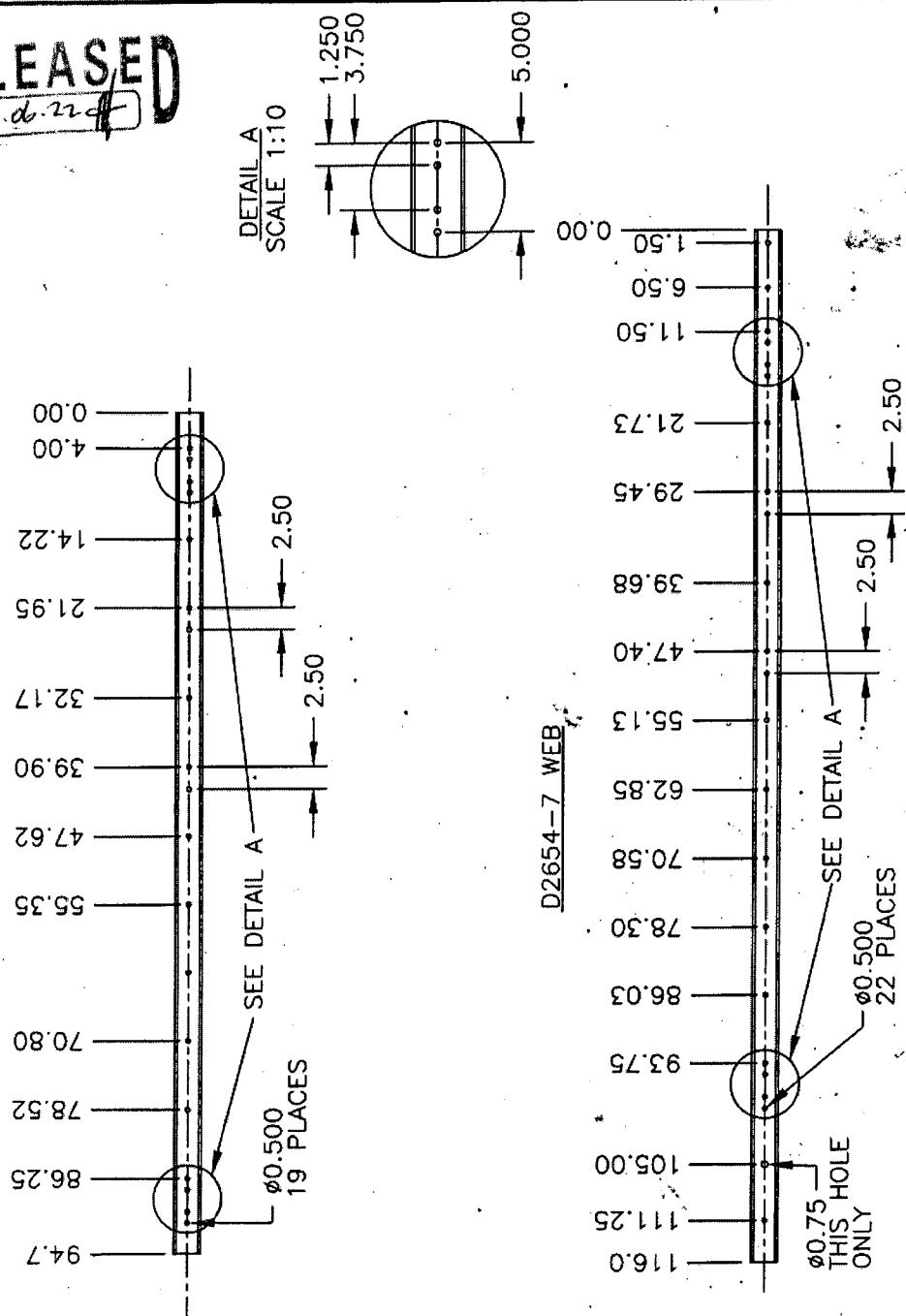
REV. E

SHEET 2 OF 2

SCALE
1:20

RELEASED
04.06.22

D2654-5 WEB



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